

25

Date: Friday, 5/25/2007 12:48:11 PM
 User: Kim Johnston

Process Sheet

BLUR

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE
 Job Number : 32670
 Estimate Number : 10973
 P.O. Number : N/A Part Number : D206667203 BL
 This Issue : 5/25/2007 S.O. No. : N/A Drawing Number : D206-667-243 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B
 Previous Run : 32669 Material : N/A
 Written By : Due Date : 6/20/2007 Qty: 1 Um: Each
 Checked & Approved By : John 05.28
 Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell
 Skid tubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

KS 07.06.04. ①

2.0

D6004115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube B29114

Check OD = 2.500"; ID = 1.800"

MS 07/06/20 ①

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

MS 07/06/20 ①

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/06/20 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:48:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 32670

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

MS 07/06/20 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/06/20 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.06.22 ②

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

JD 7-7-3

1-Polish entire outside surface of crosstube

BE 07-07-03 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-7-3

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

EL 7-7-3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:48:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 32670

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

Handwritten signature
070705
JD 7-7-5 1

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-7-5

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature
JD 7-7-5 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:48:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 32670

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 4113

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C207/07/06 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C207/07/09 ②

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

C207-10 ①

20.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

32164

87 07-07-10

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

29286

87 07-07-10

22.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

104093

87 07-07-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:48:11 PM
User: Kim Johnston

Process Sheet

BLUE

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 32670

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 07-07-10

24.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

RD: 4198 C20710718 ①

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

RT 07-07-10

3-Paint outside crosstube with Deflect blue White Iron as per QSI 005 4.2

Per P/O 4198

25.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

Defect-23 ①

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description

Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

32020

RT 07-07-24

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description

Batch

2 D2892-1

Support

53610

RT 07-07-24

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description

Batch

4 MS21920-22

Clamp

102389

RT 07-07-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:48:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 32670

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

07-07-24

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/24

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102850

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M104118

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M104936

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

07/07/24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/07/06
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:48:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 32670

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-32A

Bolt

M104583

36.0

AN960JD516

Washer



CP Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M104156

CP 07/07/240

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



See notes



Comment: INSPECT 100% KITS FOR COMPLETENESS

CP 7/25

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

CP 7/25

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CP 07/26

Job Completion



CP 07-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | |
|---|----------------------------------|
| DART AEROSPACE LTD | Work Order: 32670 |
| Description: Crosstube Assembly | Part Number: D206-667-243 |
| Inspection Dwg: D206-667-243 Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

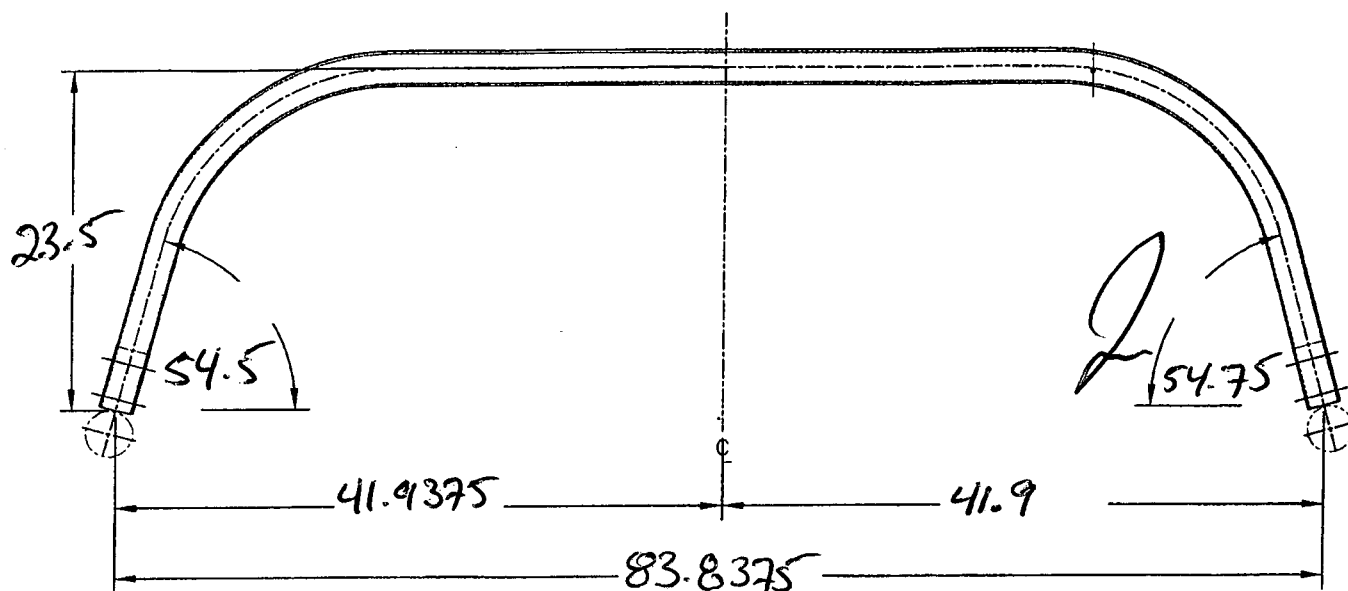
| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 2.490 | +0.005/-0.000 | 2.490 | ✓ | | |
| | 2.018 | +0.005/-0.000 | 2.019 | ✓ | | |
| | 2.079 | +0.005/-0.000 | 2.079 | ✓ | | |
| | 2.145 | +0.005/-0.000 | 2.145 | ✓ | | |
| | 2.209 | +0.005/-0.000 | 2.209 | ✓ | | |
| | 2.287 | +0.005/-0.000 | 2.287 | ✓ | | |
| | 2.363 | +0.005/-0.000 | 2.363 | ✓ | | |
| | 2.433 | +0.005/-0.000 | 2.434 | ✓ | | |
| | 0.200 | +/-0.010 | .200 | ✓ | | |
| | 0.500 x 30° | +/-0.010 | .500 | ✓ | | |
| | R0.063 | +/-0.010 | .063 | ✓ | | |
| | R0.500 | +/-0.010 | .500 | ✓ | | |
| | 4.438 | +/-0.030 | 4.440 | ✓ | | |
| | | | | | | |
| | | | | | | |
| SIDE B | 104.91 | +/-0.020 | 104.91 | ✓ | | |
| | 2.490 | +0.005/-0.000 | 2.490 | ✓ | | |
| | 2.018 | +0.005/-0.000 | 2.019 | ✓ | | |
| | 2.079 | +0.005/-0.000 | 2.079 | ✓ | | |
| | 2.145 | +0.005/-0.000 | 2.145 | ✓ | | |
| | 2.209 | +0.005/-0.000 | 2.209 | ✓ | | |
| | 2.287 | +0.005/-0.000 | 2.287 | ✓ | | |
| | 2.363 | +0.005/-0.000 | 2.363 | ✓ | | |
| | 2.433 | +0.005/-0.000 | 2.433 | ✓ | | |
| | 0.200 | +/-0.010 | .200 | ✓ | | |
| | 0.500 x 30° | +/-0.010 | .500 | ✓ | | |
| | R0.063 | +/-0.010 | .063 | ✓ | | |
| | R0.500 | +/-0.010 | .500 | ✓ | | |
| | 4.438 | +/-0.030 | 4.440 | ✓ | | |
| | | | | | | |

| | | | |
|------------------------|-----------------------|----------------------------|-----|
| Measured by: MB | Audited by: SA | Prototype Approval: | N/A |
| Date: 07/06/20 | Date: 01.06.22 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 06.09.01 | New Issue (P/O D206-667-203) | KJ/JLM | |

| | | | |
|--|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 32670 |
| Description: Crosstube High Aft (206L) | | Part Number: | D206-667-203 |
| Inspection Dwg: D206-667-243 Rev: B | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 23.46 | 23.58 |
| 1/2 Span | 41.86 | 41.98 |
| Angle | 54 | 56 |
| Total Span | 83.72 | 83.96 |



| Comments |
|----------|
| |
| |
| |
| |

| | |
|-----------------|--------------------------------|
| QC15 Inspection | <i>[Signature]</i> 07-07-04 |
| Date | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|--------------------------|--------------------|
| A | 07.02.06 | New Issue | KJ/JM <i>[Signature]</i> | <i>[Signature]</i> |



| | | | |
|------------------|------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # DS | APPROVED # DS | DRAWING NO. D206-667-243 | REV. B SHEET 1 OF 3 |
| DATE 05.07.26 | | TITLE CROSSTUBE ASS'Y (206L HIGH AFT) NTS | |
| A | 00.11.17 | NEW ISSUE | |
| B | 05.07.26 | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |

RELEASED
05-07-26

UNDER REVIEW

06-08-10 RA

12 draw detail F

RA

07.05.02

| Qty | Part Number | Description |
|-----|---------------|--------------------------|
| X | D206-667-243 | CROSSTUBE ASSEMBLY |
| 1 | D6004-115 | CROSSTUBE |
| 2 | D2856-400-773 | ABRASION STRIP |
| 2 | D2873-043 | NUT PLATE |
| 2 | D2873-045 | NUT PLATE |
| 2 | D2892-1 | SUPPORT |
| 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 4 | MS21920-22 | CLAMP |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

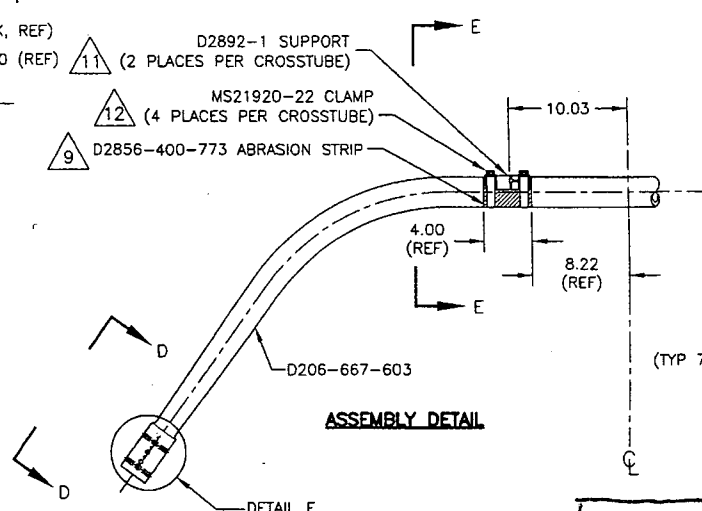
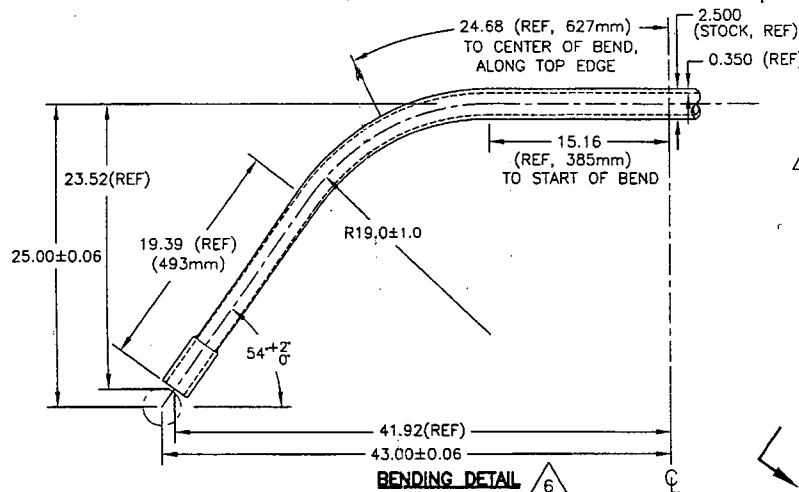
WITHOUT NOTICE

WORK ORDER

NO. 32670

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



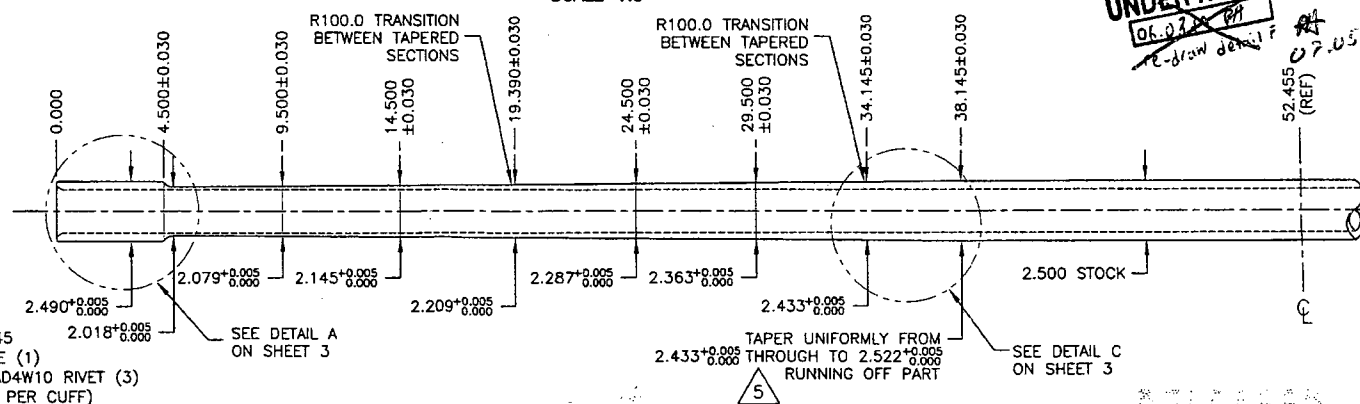
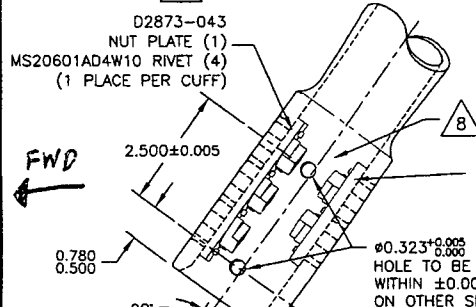
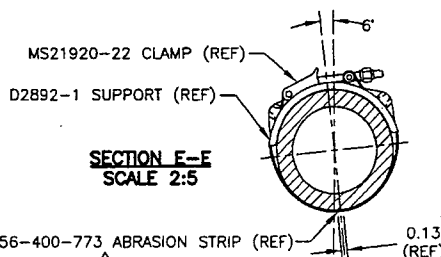
△ B $0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\emptyset 0.128$
C'SINK $\emptyset 0.225 \times 1.00$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL F
SCALE 2:5

UNDER REVIEW
06.03.26 PH
re-draw detail F
07.05.22



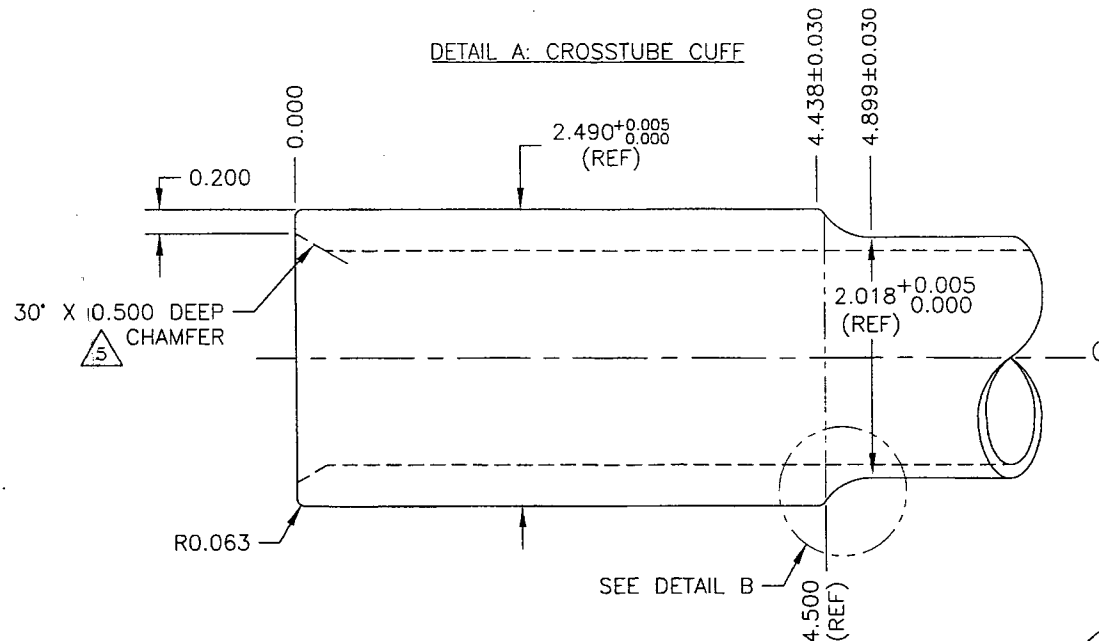
COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

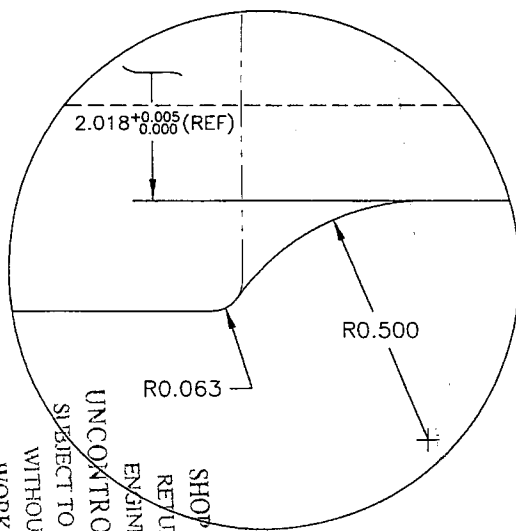
| | | |
|------------------|--|--|
| DESIGN PH | DRAWN BY PH | DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA |
| CHECKED HDS | APPROVED HDS | DRAWING NO. D206-667-243 |
| DATE 05.07.26 | TITLE CROSSTUBE ASS'Y (206L HIGH AFT) | REV. B SHEET 2 OF 3 SCALE 1:10 |

VIEW D-D:
CUFF DETAIL
SCALE 2:5
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
2670

DETAIL A: CROSSTUBE CUFF

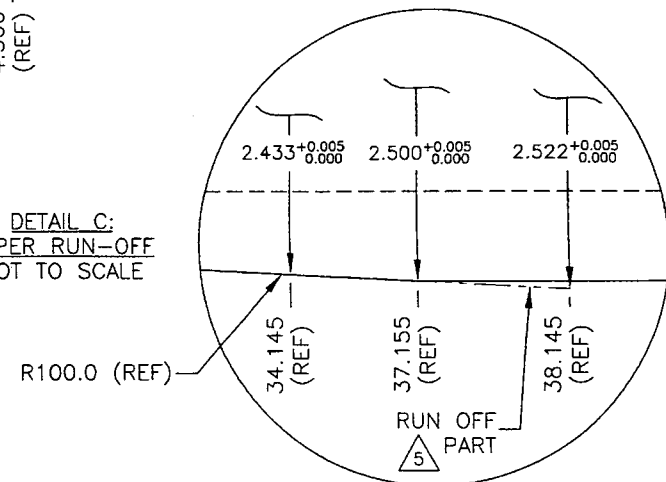


05.07.26 #
UNDER REVIEW
~~06.05.05 PH~~
Re-draw detail?
PH 07.05.02



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 32670
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
REV. B
SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN
PH
CHECKED
ADS
DATE
05.07.26

DRAWN BY
PH
APPROVED
ADS

DART DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D206-667-243
REV. B
SHEET 3 OF 3
TITLE
CROSSTUBE ASS'Y (206L HIGH AFT)
SCALE
1:1



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36827

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION: -

MODEL/TYPE: -

SERIAL NUMBER: -

TOTAL HR/LDG: -

OPERATED BY: -

BASED AT: -

INSPECTION REQUIREMENTS

Carry out FPI of (5) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (2) P/N D206-667-103 Cross tube S/N B32663 & B32664.

Qty (3) P/N D206-667-203 Cross tubes S/N's B32668, B32669 & B32670.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (5) Cross Tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

(5) cross tubes inspected. (5) PASSED inspection / (0) FAILED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

DATE July 6, 2007

INSPECTED BY:

[Signature]
B. VURPILOT

INSPECTION
STAMP(S)

N/R

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

4113

ADDRESS:

CONTACT NAME:

Linda

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

Day Aerospace

| | | |
|----------------------------|--|---------------|
| N° DE COMMANDE - ORDER NO. | DÉP. - DEPT. | DATE 07/07/18 |
| VENDU À - SOLD TO | EXPÉDIÉ À - SHIP TO Atelier Debasselage | |
| ADRESSE - ADDRESS | ADRESSE - ADDRESS | |

| DATE D'EXPÉDITION - SHIPPING DATE | VIA | CONDITIONS - TERMS | N° D'ENR. DE TAXE - TAX REG. NO. | VENDEUR - SALESPERSON |
|-----------------------------------|-----------|---------------------------|----------------------------------|-----------------------|
| | 1 set | blue au Ebas | | |
| | 2X | D2646 B 33614 | | |
| | 44X | D2651-1 B 33608 | | |
| | 2X | D2655 B 33611 | | |
| | 4X | D2658 B 33612 | | |
| | 2X | D2891-1 B 33609 | | |
| | 2X | D2892-1 B 33610 | | |
| | 2X | D2968-043 B 33613 | | |
| | 8X | D3394-043 B 33615 | | |
| | 1X | D206-667-103 B 32664 | | |
| | 1X | D206-667-203 B 32670 | | |
| | 1X | D206-642-441 B 31981A | | |
| | 1X | D206-642-441 B 32496A | | |
| | 2X | D2646 B 32375 repaint | | |
| | 8X | D3394-043 B 33138 repaint | | |
| | TPS/GST | | | |
| | TVP/PST | | | |
| 214701 | SIGNATURE | N° LIC. - LIC. NO. | TOTAL | |